

FIG. 1

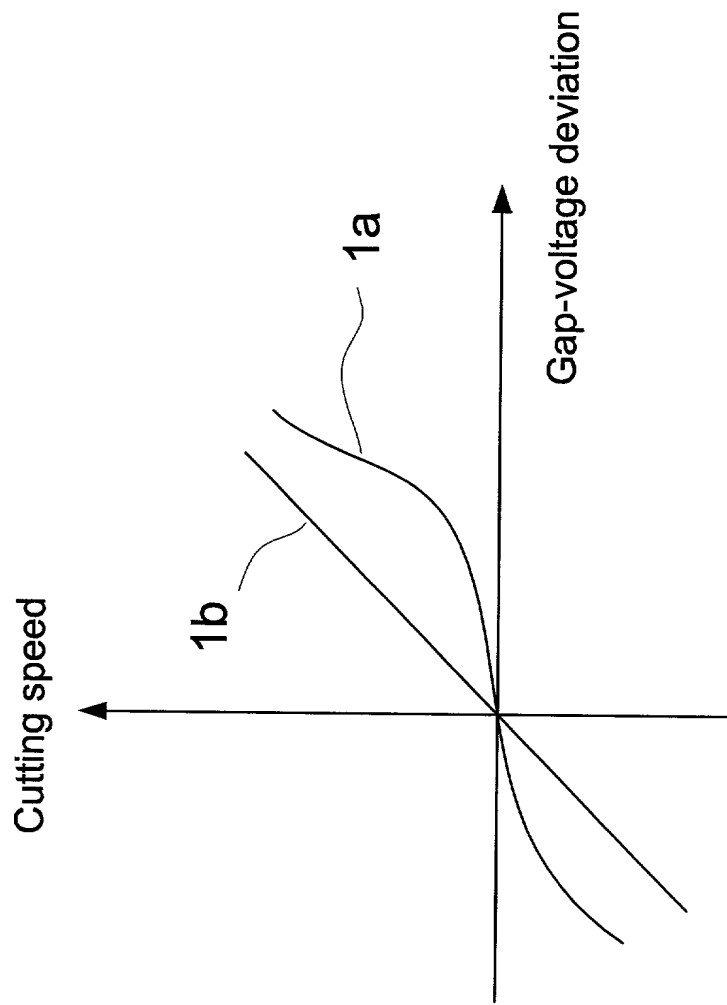


FIG. 2

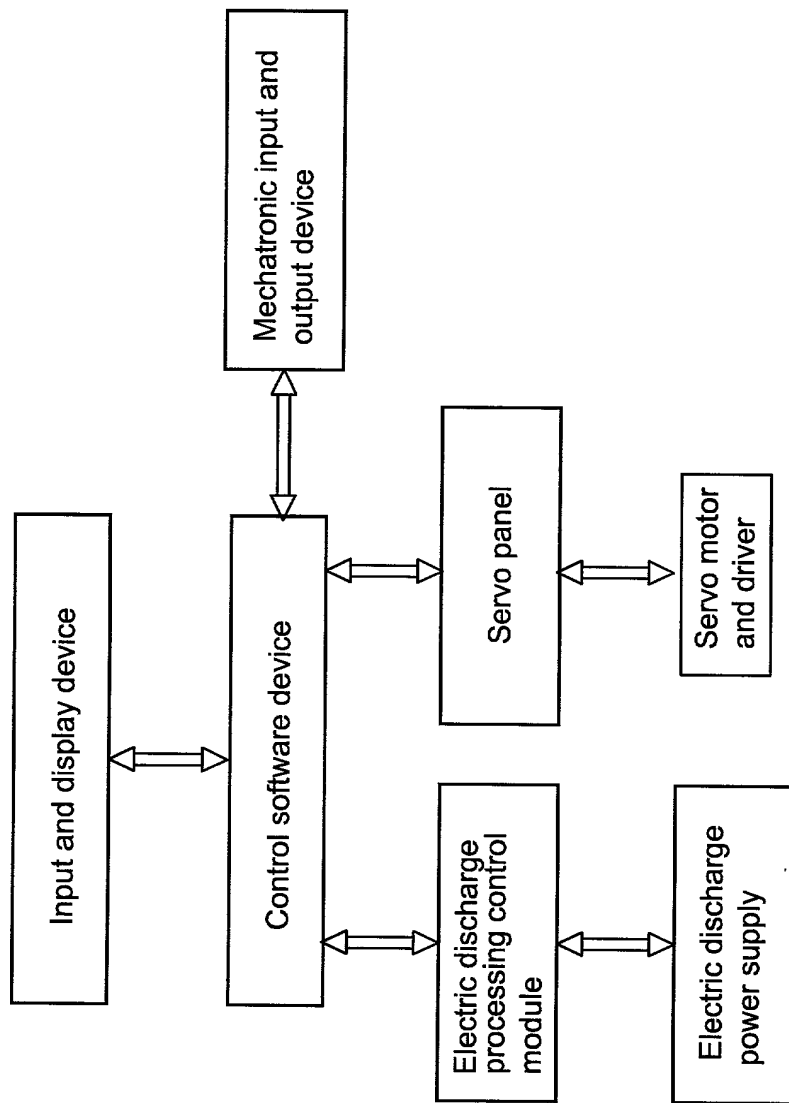


FIG. 3

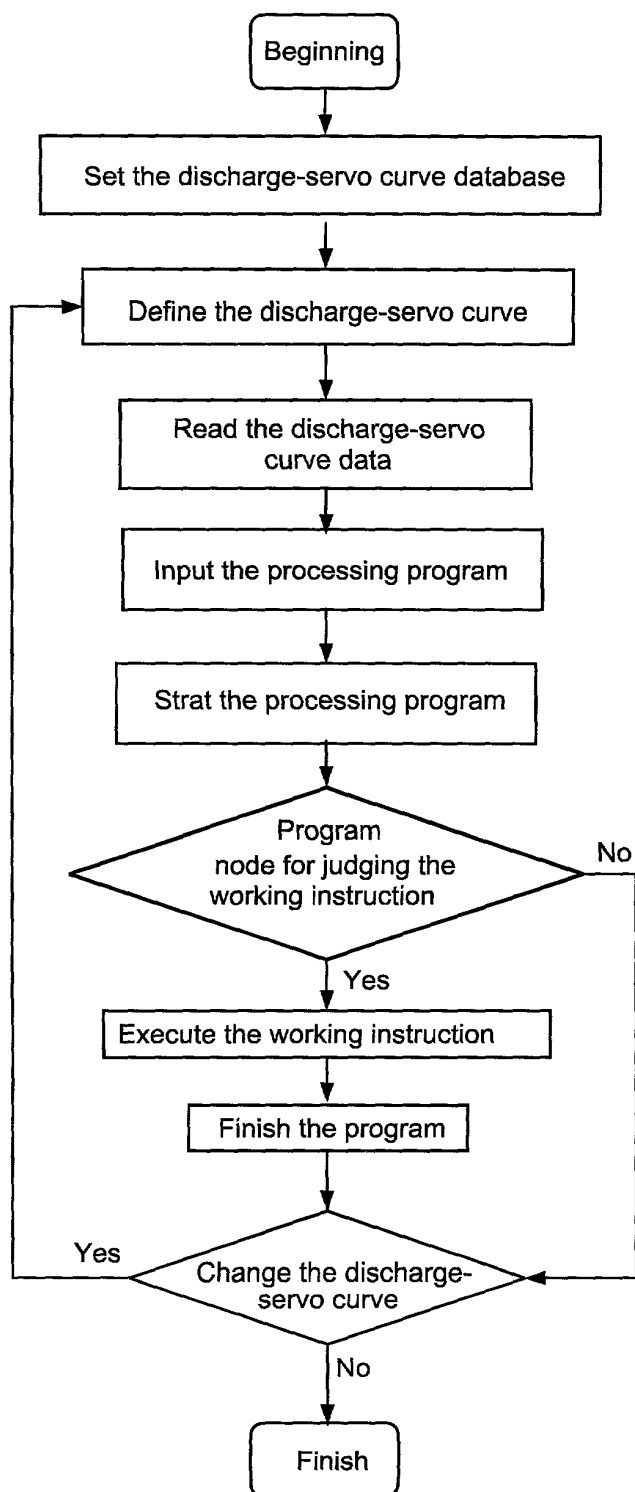


FIG. 4

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graph TD; 10([Beginning]) --> 11[Set the discharge-servo curve database]; 11 --> 12[Define the discharge-servo curve parameter]; 12 --> 13[Read the initial discharge-servo curve data]; 13 --> 14[Input the processing program]; 14 --> 15[Start the processing program]; 15 --> 16{Program node for judging the working instruction}; 16 -- Yes --> 17[Execute the working instruction]; 16 -- No --> 18{Program node for judging the discharge-servo curve instruction}; 17 --> 18; 18 -- Yes --> 19[Access the discharge-servo curve data]; 18 -- No --> 20([Finish the processing]); 19 --> 16;
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The flowchart illustrates the following steps:

- Beginning
- Set the discharge-servo curve database
- Define the discharge-servo curve parameter
- Read the initial discharge-servo curve data
- Input the processing program
- Start the processing program
- Decision: Program node for judging the working instruction. If Yes, proceed to step 17; if No, proceed to step 18.
- Execute the working instruction
- Decision: Program node for judging the discharge-servo curve instruction. If Yes, proceed to step 19; if No, proceed to step 20.
- Access the discharge-servo curve data
- Finish the processing

FIG. 5

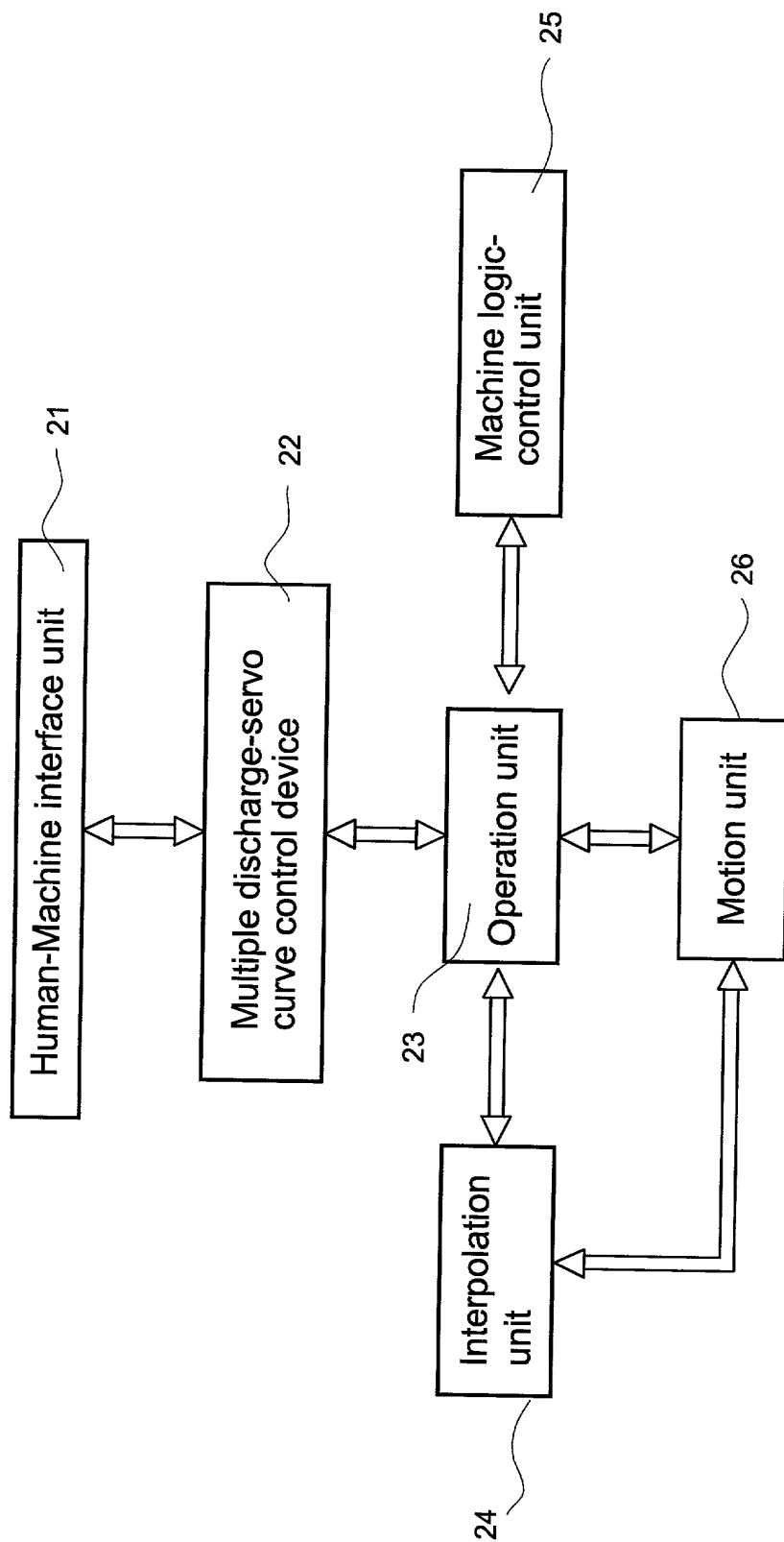


FIG. 6

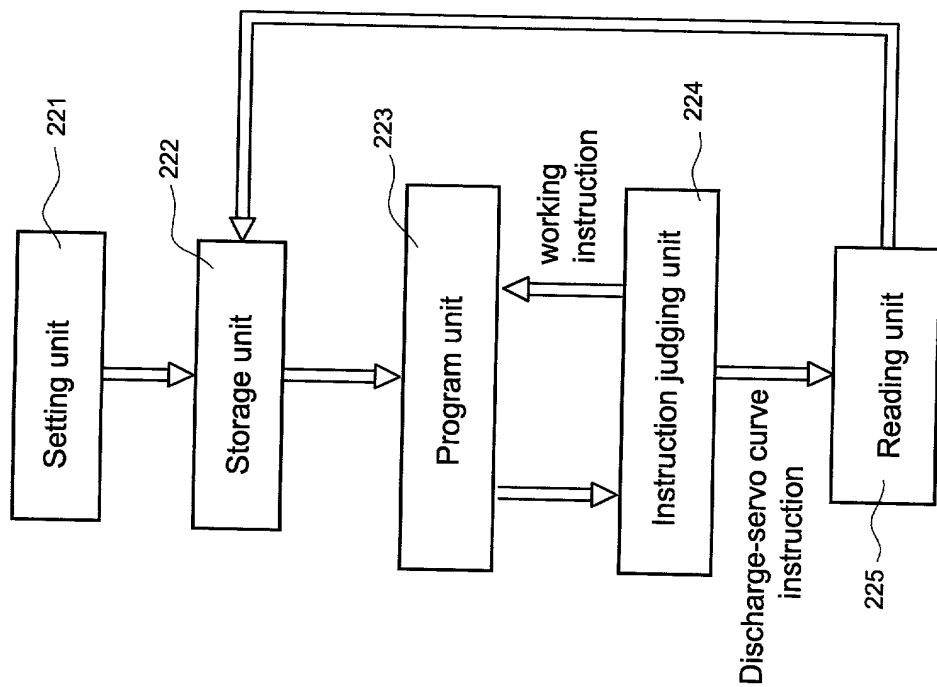


FIG. 7